

# Work Order ID 84475

**\*84475\***

Page 1

May-15-12 1:01:56 PM

Item ID: D206-642-411

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 5/14/12 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 1.00

**\*1\***

Customer:

Reference: rework - ECN09-531

Approvals:

Process Plan: *[Signature]*

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D206-642

O

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile and create labels per PPP D206-642-411 CHG006

<b>DART</b>			
TRANSPORT CANADA APPROVAL # 09-89			
PN	D206-642-411	CHG	CHG004
DESC	Skidtube LH High	SIC	SH98-4
LOT	B34556	SIC	SA00475SE
MODEL	Bell 206L/L1/L3/L4	SIC	
US PATENT 5,735,484 CANADA FOREIGN PATENTS PENDING			
MADE IN CANADA			

TEL: 1-613-632-3336  
FAX: 1-613-632-4443

*Skidtube*

*dfj Garmus 12-6-7*

*52*

*7*

# Work Order ID 84475

**\*84475\***

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Item ID: D206-642-411 Accept **\*N9000040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube LH  
 Start Date: 5/14/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 5/14/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference: rework - ECN09-531

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
101		0.00							
<b>*101*</b>									
HandFinish									
Hand Finishing	<p><b>Memo</b></p> <p>PULL FROM HK:</p> <p>1 X D206-642-411 B34556</p> <p>UPDATE TO CHG006 PER ECN08-538 &amp; 09-531 DSI9421/9440</p> <p>REMOVE WEARPLATES:</p> <p>6 X D2648-3 B33059</p> <p>1 X D2656-15 B32579 ✓</p> <p>1 X D2656-23 B34171</p> <p>1 X D2656-37 B33217</p> <p>1 X D3429-1 B34012</p> <p>RETURN TO STK</p> <p>DISCARD HARDWARE</p> <p>ADD:</p> <p>6 X D3537-1 B _____</p> <p>1 X D3537-3 B _____</p> <p>1 X D3535-15 B _____</p> <p>1 X D3536-15 B _____</p> <p>1 X D3535-23 B _____</p> <p>1 X D3536-23 B _____</p> <p>1 X D3535-37 B _____</p> <p>1 X D3536-37 B _____</p> <p>60 X MS27039C1-08 B _____</p> <p>60 X AN960C10L (NAS1149C0332R)</p> <p>B _____</p>								

1x 4 M 12/06/04

# Work Order ID 84475

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Item ID: D206-642-411 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube LH  
 Start Date: 5/14/12 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 5/14/12 Req'd Qty: 1.00 \*1\* Customer:  
 Reference: rework - ECN09-531

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Pick Kit	0.00							
*110*									
Packaging	Memo	0.00							
Packaging	REMOVE FROM KIT TO UPDATE TO CHG006: 1 X D2707-043(OR D2968-043)-SCRAP 1 X AN960JD1016 B <u>5879</u> 30275 1 X AN970-4 B <u>104885</u> 1 X MS21042-4 B <u>104683</u> 1 X AN4-5A B <u>100837</u> 1 X AN960JD416 B <u>104746</u> 1 X D2655 B <u>32788</u> RETURN TO STK  ADD TO KIT: 1 X D3407-043 B <u>87826</u> 1 X D3456-1 B <u>81977</u> 2 X D3457-1 B <u>12162</u> 1 X MS21043-4 B <u>119017</u> 1 X AN4C5A B <u>119094</u> 1 X AN960C416 B <u>83307</u> 1 X D3413-1 B								

# Work Order ID 84475

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Item ID: D206-642-411

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 5/14/12 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 1.00 **\*1\***

Customer:

Reference: rework - ECN09-531

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
<b>*120*</b>	<i>insure sabbies are correct</i>								
QC	Memo	0.00							
Quality Control	<i>end in Box</i>								
130		0.00							
<b>*130*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	REPACKAGE PER PPP USING NEW B/N NEW LABELS AND PAPERWORK REQ'D Identify and pack for shipping as per PPP D206-642-411 Location: <i>82</i> PPP Rev: <i>E</i>								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*12/6/20*

*12/6/20*

*12/6/20*

*MF*  
*12-06-21*

# Picklist Print

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Work Order ID: 84475  
Parent Item: D206-642-411  
Parent Item Name: Skidtube LH

Start Date: 5/14/12  
Start Qty: 1.00

Required Date: 5/14/12  
Required Qty: 1.00

Comments: IPP Rev:K05.10.11 Revised picklist per CHG004KJ/CP/JLM  
IPP Rev:L 07-12-04 ECN 1080p DD verified by:ec  
IPP rev:M 08-09-29 as per DSI9421 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-5A Bolt		Purchased	No				Each	974.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		974							
				120562		974							
AN4C5A BOLT		Purchased	No				Each	199.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		199							
				112243		139							
				119017		60							
AN960C416 washer	NAS1149C0463R	Purchased	No				Each	0.0000		1			
AN960JD1016 Washer	NAS1149C1063R	Purchased	No				Each	369.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		369							
				5519		369							
AN960JD416 Washer	NAS1149D0463J	Purchased	No				Each	30.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		30							
				116289		10							
				119097		20							

M1008578

1

M1190978

M114746

12/6/12

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Work Order ID: 84475

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

AN970-4 Purchased No Each 203.0000  
Washer

-1 m104885

Location	Loc Qty	Loc Code
ST344	203	
115936	11	
120308	3	
120644	30	
121285	159	

D206-642-411 Manufactured No Each 1.0000  
Skidtube LH

Location	Loc Qty	Loc Code
FG081	1	B3-1556
78486	1	

D2648-3 Manufactured No Each 9.0000  
Wearpad

Location	Loc Qty	Loc Code
ST	-10	B33054
81513	9	
ST237A	19	

D2655 Manufactured No Each 30.0000  
Ring

Location	Loc Qty	Loc Code
ST464	30	
44295	15	
45738	15	

D2656-15 Manufactured No Each 6.0000  
Wearshoe

Location	Loc Qty	Loc Code
FP	5	B32579
83601	5	
Mezz	1	
51455	1	

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Shop Packet Print

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Work Order ID: 84475

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D2656-23 Manufactured No  
Wearshoe

Each 9.0000

91-1 12/06/01

Location	Loc Qty	Loc Code
Mezz	9	
43407	2	B34171
51468	7	

✓1

D2656-37 Manufactured No  
Wearshoe

Each 21.0000

91-1 12/06/01

Location	Loc Qty	Loc Code
Mezz	21	B35217
34510	2	
44550	7	
46497	1	
53019	11	

✓1

D3407-043 Manufactured No  
Tow Ring

Each 14.0000

B83 3 < 5 S C C

Location	Loc Qty	Loc Code
ST420	1	
79232	1	
ST463	13	
68339	2	
77504	10	
78841	1	

D3413-1 Manufactured No  
Ring

Each 73.0000

1 12/06/01

Location	Loc Qty	Loc Code
ST420	4	
79233	4	
ST464	69	
76754	1	
80224	7	
83307	41	
83867	20	

1 ✓

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Work Order ID: 84475

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3429-1 Manufactured No Each 16.0000  
Wearpad

Location	Loc Qty	Loc Code
FP002	16	B34012
40438	2	
43706	1	
44579	12	
65692	1	

44-1 12/06/12

X1  
1

D3456-1 Manufactured No Each 168.0000  
Washer

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST044	161	
80252	1	
81876	60	
83584	100	

1  
2

D3457-1 Manufactured No Each 35.0000  
Washer

Location	Loc Qty	Loc Code
FG	10	
32409	10	
ST044	25	
67779	1	
81977	24	

2  
44-1 12/06/12

D3535-15 Manufactured No Each 17.0000  
Wearshoe

Location	Loc Qty	Loc Code
FP001	17	
80328	4	
81354	13	

X1

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Work Order ID: 84475

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3535-23 Manufactured No Each 22.0000  
Wearshoe

Location	Loc Qty	Loc Code
FP001	22	
81355	2	
83375	20	

HL 1 12/06/04

D3535-37 Manufactured No Each 4.0000  
Wearshoe

Location	Loc Qty	Loc Code
FP001	4	
71668	4	

HL 12/06/04

D3536-15 Manufactured No Each 20.0000  
Gasket

Location	Loc Qty	Loc Code
FP002	20	
73318	14	
81343	6	

HL 1 12/06/04

D3536-23 Manufactured No Each 16.0000  
Gasket

Location	Loc Qty	Loc Code
FP002	16	
74510	1	
83377	15	

HL 12/06/04

D3536-37 Manufactured No Each 19.0000  
Gasket

Location	Loc Qty	Loc Code
FP002	19	
66823	7	
82623	12	

HL 12/06/04

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Work Order ID: 84475  
 Parent Item: D206-642-411  
 Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No Each 41.0000  
 Wearpad

56 12/06/01

Location	Loc Qty	Loc Code
FG	10	B84091
79833	10	
FP002	31	
69817	5	
81362	22	
83254	1	
83255	3	

46  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_

D3537-3 Manufactured No Each 28.0000  
 Wearpad

56 12/06/01

Location	Loc Qty	Loc Code
FP002	28	
78836	5	
81363	23	

VI  
 \_\_\_\_\_  
 \_\_\_\_\_

MS21042-4 Purchased No Each 1,071.0000  
 USE MS21042L4

-1 12/4/17  
 M104683

Location	Loc Qty	Loc Code
ST299	1071	
100743	9	
119124	1000	
5461	1	
6844	19	
7690	24	
8182	6	
9063	8	
9229	4	

\_\_\_\_\_

# Picklist Print

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Work Order ID: 84475

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

MS21043-4 Purchased No Each 1,546.0000

1

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	40	
104603	40	
ST301	1506	
119546	185	
121162	821	
121652	500	

MS27039C1-08 Purchased No Each 1,142.0000

60

SCREW

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	1	
116022	1	
ST292	1122	
120308	354	
121068	108	
121162	660	
ST293	19	
116373	3	
118077	14	
119309	2	

NAS1149C0332R Purchased No Each 3,354.0000

60

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	219	
119736	196	
120648	23	
ST298	3135	
121255	11	
121509	3124	

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Shop Packet Print

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Date: Tuesday, 8/21/2007 2:07:39 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE  
Job Number : 34135A  
Estimate Number : 10522  
P.O. Number : *NA* Part Number : D206642441  
This Issue : 8/21/2007 S.O. No. : *N/A* Drawing Number : D2650 REV E  
Prsht Rev. : *NC* Project Number : *N/A*  
First Issue : *NA* Type : LANDING GEAR Drawing Revision : E  
Previous Run : 33929A Material :  
Written By : *JA 07.08.21* Due Date : 9/20/2007 Qty: 1 Um: Each  
Checked & Approved By :  
Comment : Est Rev: H.05.10.11 Added D3429-1 per CHG002 KJ/CP/JL  
M

## Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002 *NA*

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD *B33880*

*DP 7-9-6*

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap *B29328 BE 7-9-10*

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube.

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod *M104221/M105058*

4-Grind weld flush to cap on top surface only.

*BE 7-9-10*

Date: Tuesday, 8/21/2007 2:07:39 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34135A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

- ✓ 5-Cut aft end 138.60" from front of tube
- ✓ 6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".
- ✓ 7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".
- ✓ 8-Open using #6 Drill Bit
- ✓ 9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail
- ✓ 10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650
- ✓ 11-Deburr and Blow out all chips form inside the tube

AWM/K  
07/09/19

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM  
07/09/19



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0

D26547

206 L Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number\* Description Batch

1 D2654-7

Web

B-34075

AWM  
07/09/19

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- ✓ 1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)
- ✓ 2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)
- ✓ 3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

AWM/K  
07/09/19

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Start Date: 07/09/19 Time: 2:00

Finish Date: Time:

A/R: Sikaflex-291\*

Sikaflex expiry date:

105488/105469  
08/01/01

Date: Tuesday, 8/21/2007 2:07:39 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34135A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

GA 2/21/20

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number Description Batch

23 D2649

Crossbolt spacer

B33214 BE 07-09-27

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

M/05/38

BE 07-09-27

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

7-9-28

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2680-041

Nut Plate

G30460

7-9-28

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 CCR264SS3-3

Rivets

M2525

7-9-28

13.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

Date: Tuesday, 8/21/2007 2:07:39 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34135A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

2 M7885/3-4-3

Rivets

M102515 @ M 7-9-28

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

M 7-9-28

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

D 07-10-02

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

E 07/10/03

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M 07/10/05

18.0

SPRAY PAINTING

SPRAY PAINTING



Comment: Make sure Nut Plate Thread protected use paint screw

Issue P.O.

Atelier Debosselage

Spray Paint Delfleet Blue

Clear with Delfleet

White Enamel per Dst  
W POWDERCOAT

M105086 07/10/05

19.0

QC3

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

M 07 10 10



20.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

B33059

BR

BR 07-10-11

Date: Tuesday, 8/21/2007 2:07:39 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34135A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

21.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe

B 32579

BR

22.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe

B 34171

BR

23.0

D265637

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe

B 33217

BR

24.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad

B 34012

BR

25.0

ALS41032130

Insert

\*



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts

M 105855

or (see QSI 017)

BR

BR

07-10-11



Date: Tuesday, 8/21/2007 2:07:39 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34135A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN960JD10L

Washer



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer

*M104885*

*BR*

27.0

MS27039108

Screw



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 MS27039-1-08

Screw

*M105433*

*BR*

28.0

D26511

Plug



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

Plugs

*B 33185*

*BR*

29.0

D26513

O-Ring



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings

*B 33452*

*BR*

30.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

*M 10338*

*BR*

31.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

*M 15194*

*BR*  
*BR 07-10-11*

Date: Tuesday, 8/21/2007 2:07:39 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34135A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 MS27039-4-06 Screw

32.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap

B33289

*BR*

33.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960JD10L

Washer

M 104885

*BR*

34.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-08

Screw

M 105433

*BR*

35.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

M 105469

Sikaflex expiry date:

08-01

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

M 105469

Sikaflex expiry date:

08-01

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch:

M 105694

*FL*

07/10/11

(1)

*BR 07-10-11*

Date: Wednesday, 9/12/2007 11:44:27 AM  
 User: Kim Johnston

## Process Sheet

41

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L/L3/L4 HIGH GEAR SKID  
 Job Number : 34556  
 Estimate Number : 10525  
 P.O. Number : N/A Part Number : D206642411  
 This Issue : 9/12/2007 S.O. No. : N/A Drawing Number : N/A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : N/A  
 Previous Run : 34555 Material : N/A  
 Written By : Due Date : 10/10/2007 Qty: 1 Um: Each  
 Checked & Approved By : *[Signature]*  
 Comment : Est Rev:K 05.10.11 Revised picklist per CHG004 KJ/CP/JL  
 M

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



*[Signature]* KS 07.09.17

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-411 CHG004

2.0 34556A 206 L HIGH GEAR SKIDTUBE



Comment: Sub-Component 206 L HIGH GEAR SKIDTUBE

D206-642-441 B34135A

3.0 PACKAGING PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D2652 Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
 24 D2652 Bushing B33350-  
 1 D206-642-441(REF) B34135A

5.0 D2655 Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
 1 D2655 Tow Ring B32988-

Date: Wednesday, 9/12/2007 11:44:27 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 34556

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D2659

Lug Assembly



*EP*



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2659 Lug Assembly B34076-

7.0

D2712

Set Screw



*EP*



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

10 D2712 Set Screw B34172-

8.0

D29321

206 Saddle Left side



*EP*



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2932-1 Saddle B34615-

9.0

D29331

206 Saddle Left



*EP*



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2933-1 Saddle B33353-

10.0

D2934

Saddle Spacer



*EP*



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2934 Saddle Spacer B34173-

11.0

D2935

Saddle Spacer



*EP*



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2935 Saddle Spacer B34003-

*EP 7/10/12*

Date: Wednesday, 9/12/2007 11:44:27 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 34556

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

D29381

206 Saddle Left side



*CP*



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2938-1

Saddle

*B 33355*

13.0

D29391

206 Saddle Left side



*CP*



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2939-1

Saddle

*B 33361*

14.0

D2968043

Tow Ring



*CP*



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2968-043

Tow Ring

*B 30275*

15.0

AN337A

Bolt



*CP*



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN3-37A

Bolt

*M 103962*

16.0

AN341A

Bolt



*CP*



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN3-41A

Bolt

*B 1104625*

17.0

AN45A

Bolt



*CP*



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

*M 100857*

*CP 9/12/07*

Form: minness

Date: Wednesday, 9/12/2007 11:44:27 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 34556

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0 1 AN4-5A

Bolt

Bolt

18.0

AN46A



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 AN4-6A

Bolt

M104322 -

19.0

AN511A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN5-11A

Bolt

M105442 -

20.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN5-12A

Bolt

M104885 -

21.0

AN513A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN5-13A

Bolt

M15928 -

22.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 AN960JD10

Washer

M100151 -

Date: Wednesday, 9/12/2007 11:44:27 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 34556

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description:

23.0

AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty Part Number Description Batch

1 AN960JD1016 Washer M5519 -

24.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total: 25.0000 Each(s)

Qty Part Number Description Batch

25 AN960JD416 Washer M104746 -

25.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Qty Part Number Description Batch

8 AN960JD516 Washer M104156 -

26.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty Part Number Description Batch

1 AN970-4 Washer M104885 -

27.0

MS21042L3

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Qty Part Number Description Batch

12 MS21042L3 Nut (or -3) M104625 -

28.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total: 13.0000 Each(s)

Qty Part Number Description Batch

13 MS21042L4 Nut (or -4) M104683 -

*EP 7/10/12*

Date: Wednesday, 9/12/2007 11:44:28 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 34556

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description:

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



10-10-12 @



Comment: INSPECT 100% KITS FOR COMPLETENESS

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-411

Location:

PPP Rev: D

CP 10/10/12

31.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

10/10/16

Job Completion



u 07-10-15

B 34135A



Part Number D206-642-411  
Description 206 SKIDTUBE INSTALLATION

Chg.	Date	By	Relevant Documents
1	98.12.14	DS	MDL- D206-642 REV. I
2	99.04.28	DS	- MDL- D206-642 REV. J - ADDED SHOULDER SPACERS PER DSI 9150 REV. A - D2655 TOW RING SHIPPED LOOSE RATHER THAN INSTALLED ON SKIDTUBE
3	00.03.14	DS	CHANGE TO D2968-043 TOW RING PER DSF 9181 REV. A
4	05.10.04	CP	Add D3475-1 MDL- D206-642 REV. O
005	08.10.07	HA	DSI 9421 Rev. A, D2650 Rev. F (ECN 08-538)
006	09.02.19	HA	DSI 9421 Rev. B, DSI 9440 Rev. A, D206-648 Rev. B, D3414 Rev. B (ECN 09-538)

✓ 84474 - 38778

✓ 84475 - 34556

✓ 84476 - 38777

✓ 84477 - 34560

# **ENGINEERING CHANGE NOTICE** **DART AEROSPACE LTD**

Date: 09.02.18	Job No.: 00569	ADR Yes/No: N	ADR Date:	ECN #: 09- 531
Product No.: D206-642		Created By: AJS	Approved By: <i>[Signature]</i>	
Product Name: Skidbte Installation		Checked By: <i>[Signature]</i>	General Manager Approval:	

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	<i>LL 09/02/19</i>
Production Engineering Coord	Y	EC/DD	<i>EC/DD 09/02/19</i>
Production Document Control	Y	JLD	<i>JLD 09.02.19</i>
Customer Technical Support			

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord			
QC Coordinator	Y	JM	<i>JM 09.02.19</i>
Marketing	Y	SW	<i>SW 09.03.19</i>
Customer Order Processing			

Reason for Change: DESIGN IMPROVEMENT CHANGE FROM CARBON STEEL TO STAINLESS STEEL

## **Documents Affected:**

DSI 9421 REV B  
DSI 9440 REV A  
D206-648 REV B  
D3414 Rev B

PARTS MUST COMPLY ☐

PREVIOUS PARTS SATISFACTORY ☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	KJ		<i>09.02.19</i>
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		<i>09.02.19</i>
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		<i>09.02.19</i>
10	Update Controlled PDF Files	Y	KJ		<i>09.02.19</i>
11	Update Master Document List (MDL)	Y	AJS	<i>Rev. U</i>	<i>09.02.19</i>
12	Update Document Record (DR)	Y	KJ		<i>09.02.19</i>
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	<i>SEE BELOW</i>	<i>09.02.19</i>
18	Create / Update PPP's	Y	KJ		<i>09.02.19</i>
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		<i>09.02.19</i>
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		<i>09.02.19</i>
22					
23					

## **Description / Action:**

Roll -111/-112/-211/-212/-213/-214 to Change number 005 (Per DSI 9421)

*-141/-241 @ CHG 004, -143/-243 @ CHG 002 (PER DSI 9440 Rev. A)*

Roll -311/-312/-411/-412 To Change number 006 (Per DSI 9421)

*-341/-441 @ CHG 003, -443 @ CHG 001, 343 @ CHG 002 (PER DSI 9440 Rev. A)*

Previous parts Disposition: Depelete existing stock of -111/-112/-211/-212/-213/-214 parts @ Change 004 repectively. DO NOT mix parts from change 004 and change 005

Previous parts Disposition: Depelete existing stock of -311/-312/-411/-412 parts @ Change 005 DO NOT mix parts from change 005 and change 006

*D206-648-011/-013 NOW AT CHG002 (D206-648 Rev. B) -DO NOT MIX PARTS*

ECN Verified & Complete: *[Signature]*

Date: *09/03/16*

**ENGINEERING CHANGE NOTICE**  
**DART AEROSPACE LTD**

Date: 09.02.18	Job No: 00569	ADR Yes/No: N	ADR Date:	ECN #: 09- 531
Product No.: D206-642	Created By: AJS	Approved By: [Signature]		
Product Name: Skidbe Installation	Checked By: [Signature]	General Manager Approval:		

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	
Production Engineering Coord	Y	EC/DD	11/09/02/19
Production Document Control	Y	JLD	09.02.19
Customer Technical Support			

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord			
QC Coordinator	Y	JM	09.02.19
Marketing	Y	SW	
Customer Order Processing			

Reason for Change: DESIGN IMPROVEMENT CHANGE FROM CARBON STEEL TO STAINLESS STEEL

**Documents Affected:**

DSI 9421 REV B  
DSI 9440 REV A  
D206-648 REV B  
D3414 Rev B

**PARTS MUST COMPLY**

☐

**PREVIOUS PARTS SATISFACTORY**

☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	KJ		09.02.19
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		09.02.19
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		09.02.19
10	Update Controlled PDF Files	Y	KJ		09.02.19
11	Update Master Document List (MDL)	Y	AJS	Rev. U	09.02.19
12	Update Document Record (DR)	Y	KJ		09.02.19
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	SEE BELOW	09.02.19
18	Create / Update PPP's	Y	KJ		09.02.19
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		09.02.19
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		09.02.19
22					
23					

**Description / Action:**

Roll -111/-112/-211/-212/-213/-214 to Change number 005 (Per DSI 9421)

-141/-241 @ CHG 004, -143/-243 @ CHG 002 (PER DSI 9440 Rev. A)

Roll -311/-312/-411/-412 To Change number 006 (Per DSI 9421)

-341/-441 @ CHG 003, -443 @ CHG 002 (PER DSI 9440 Rev. A)

Previous parts Disposition: Depelete existing stock of -111/-112/-211/-212/-213/-214 parts @ Change 004 repectively. DO NOT mix parts from change 004 and change 005

Previous parts Disposition: Depelete existing stock of -311/-312/-411/-412 parts @ Change 005 DO NOT mix parts from change 005 and change 006

D206-648-011/-013 NOW AT CHG002 (D206-648 Rev. B) -DO NOT MIX PARTS

N/A  
JW 09.03.03

ECN Verified & Complete: \_\_\_\_\_

Date: \_\_\_\_\_

4.4 206L/L-1/L-3/L-4 High Gear Skidtubes (D206-642)  
32.13 206L/L-1/L-3/L-4 High Gear Skidtubes (ICA-D206-642)

IS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-013	GROUND HANDLING KIT
30	1	1				D3407-043	TOW RING ASSEMBLY
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING
40					2	D3414-041	LUG ASSEMBLY
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

WAS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -011	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-011	GROUND HANDLING KIT
30	1	1				D2707-043 (OR D2968-043)	TOW RING
31	1	1				AN960JD1016	WASHER
32	1	1				AN970-4	WASHER
33	1	1				MS21042-4	NUT (OR MS21042L4)
34	1	1				AN4-5A	BOLT
35	1	1				AN960JD416	WASHER
36	1	1				D2655	RING
40					2	D2659	GHW LUG
41					4	AN3-37A	BOLT
42					8	D2652	BUSHING
43					4	MS21042-3	NUT (OR MS21042L3)
44					4	AN960DJ10	WASHER

DESIGN	AJS	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA
DRAWN	AJS	
CHECKED		DRAWING NO. REV. B
MFG. APPR.	N/A	DSI 9421 SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE INSTALLATIONS NTS
DATE	08.10.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC

4.3 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skid tubes (D206-642)  
 32.12 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skid tubes (ICA-D206-642)

ITEM	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1		D3536-11	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)	(MODIFY)
24B			1	1		D3536-35	GASKET	(ADD)
26A			54			MS27039-1C08	SCREW	(MODIFY)
26B			54			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-11	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-35	WEARSHOE
26A			54			MS27039-1-08	SCREW
26B			54			AN960JD10L	WASHER

4.4 206L/L-1/L-3/L-4 High Gear Skid tubes (D206-642)  
 32.13 206L/L-1/L-3/L-4 High Gear Skid tubes (ICA-D206-642)

ITEM	Qty -411	Qty -412	Qty -441	Qty -447	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-447	WEARSHOE KIT (REPLACES -443)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2656-15)	(MODIFY)
22B			1	1		D3536-15	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)	(MODIFY)
24B			1	1		D3536-37	GASKET	(ADD)
26A			60			MS27039-1C08	SCREW	(MODIFY)
26B			60			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-15	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-37	WEARSHOE
26A			60			MS27039-1-08	SCREW
26B			60			AN960JD10L	WASHER

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<del>NA</del>	DRAWING NO.	REV. 3
MFG. APPR.	N/A	DSI 9440	SHEET 3 OF 4
APPROVED	<del>NA</del>	TITLE	SCALE
DE APPR.	<del>NA</del>	WEARSHOE CHANGE	NTS
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QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

F

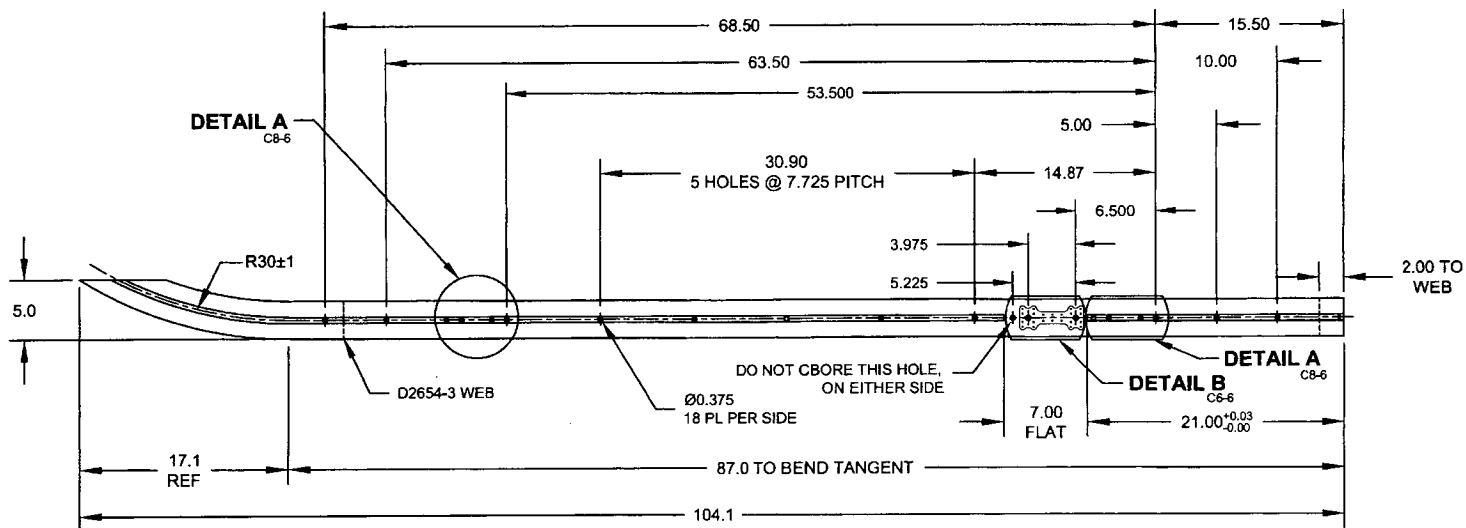
#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG CW D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

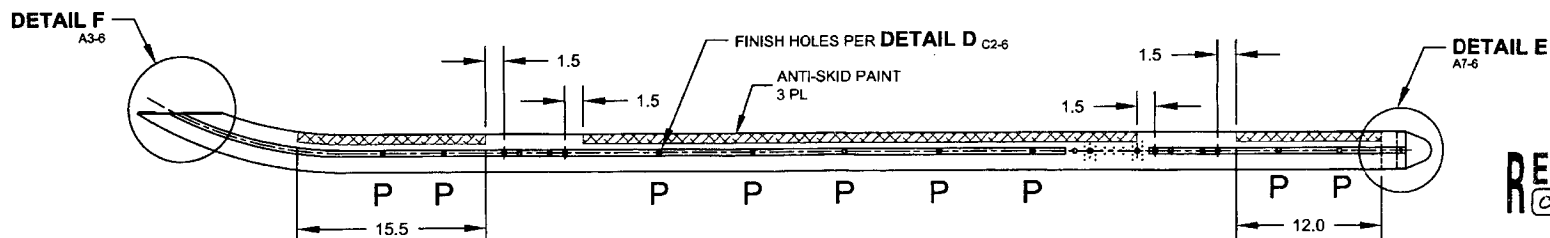
RELEASED  
08-07-23/17

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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**D2650-3 BENDING/DRILLING DETAIL**



**D2650-3 ASSEMBLY/FINISHING DETAIL**

**RELEASED**  
08 07 22 1116

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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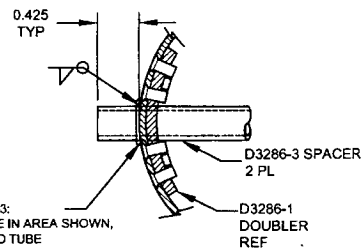


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07-09-22/117

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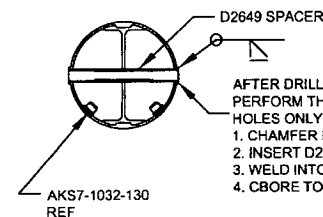


**SECTION C-C** C7-6  
SCALE NONE



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO Ø0.500
  4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE.

F



**DETAIL D**  
FOR Ø0.375 HOLES ONLY  
SCALE 3X

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. CBORE TO Ø0.313 X 0.75 DP

B4-2  
B4-3  
B4-4  
B4-5

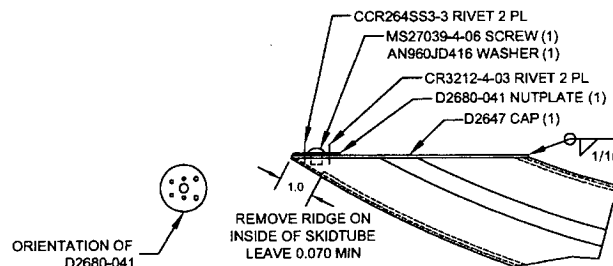
**DETAIL F NOTES:**

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

**RELEASED**  
08-09-2018

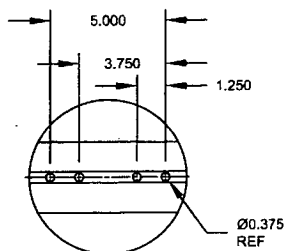
**DETAIL F**  
SCALE NONE



ORIENTATION OF D2680-041

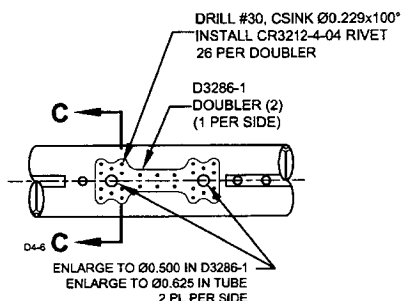
REMOVE RIDGE ON INSIDE OF SKIDTUBE  
LEAVE 0.070 MIN

**DETAIL A**  
SCALE 2X



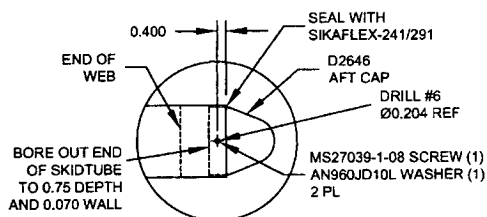
C2-2  
D7-2  
C2-3  
D7-3  
C2-4  
D7-4  
C2-5  
D8-5

**DETAIL B**  
SCALE 2X





C3-2  
C3-3

**DETAIL E**  
SCALE 2X



B2-2  
B2-3  
B1-4  
B1-5

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
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